

Work Order ID 65898

Thursday, January 27, 2011 7:17:58 AM

Page 1

Item ID: D3477-041

Accept

Setup Start

Revision ID:

Item Name: Blower Motor Inlet Adapter

Stop

Start Date: 1/27/2011 Start Qty: 2.00

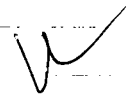
Cust Item ID:

Required Date: 2/1/2011 Req'd Qty: 2.00

Customer:

Reference:

Approvals:

Process Plan: 

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D3477

Rev B

100

0.00

Small Fab

Small Fab

Memo

0.00

Small Fab

1-Assemble as per Dwg D3477
2-Spot Weld as per Dwg D3477 and Dart QSI 004

EM-L 11/02/02

110

QC11- Inspect spot weld per QSI004

0.00

QC

Memo

0.00

Quality Control

SB 11/02/02

2

120

QC5- Inspect part completeness to step on W/O

0.00

QC

Memo

0.00

Quality Control

SB 11/02/02

2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

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Accept

Setup Start

Revision ID:

Item Name: Blower Motor Inlet Adapter

Stop

Start Date: 1/27/2011 Start Qty: 2.00

Cust Item ID:

Required Date: 2/1/2011 Req'd Qty: 2.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

Identify as per dwg & Stock Location: GA

0.00

Packaging

Memo

0.00

Packaging

140

QC21- Final Inspection - Work Order Release

0.00

QC

Memo

0.00

Quality Control

SB 11/02/02

(2)

11/02/04

MF

11-02-03

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

Thursday, January 27, 2011 7:17:55 AM

Page 1

Work Order ID: 65898

Parent Item: D3477-041

Parent Item Name: Blower Motor Inlet Adapter

Start Date: 1/27/2011

Required Date: 2/1/2011

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev: A New Issue 06-02-03 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3477-1		Manufactured	No			100	Each	0.0000	1	2	SB	11/02/02	

B65899

Flange		Manufactured	No			100	Each	6.0000	1	2	SB	11/02/07	
D3477-3													
Tube													

Location

Loc Qty

Loc Code

ST155

6

44624

2

46272

4

D3477-5		Manufactured	No			100	Each	8.0000	1	2			
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Blower Adapter Flange

Location

Loc Qty

Loc Code

ST062

8

46989

8

2 SB 11/02/07

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

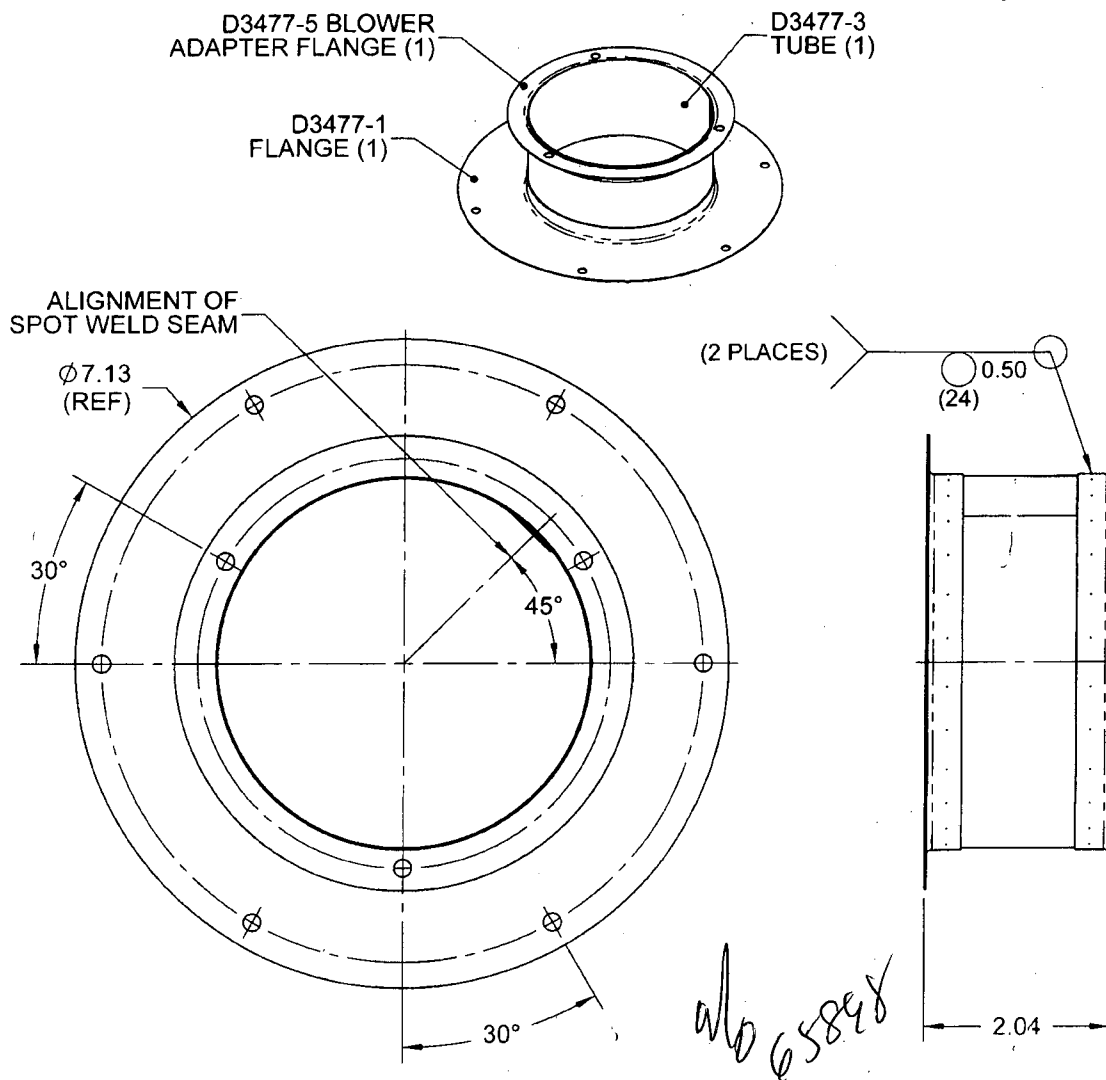
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



RELEASED
8/6/30

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>RH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3477	REV. B SHEET 1 OF 4
DATE 08.12.19		TITLE BLOWER INLET ADAPTER	SCALE 1:2
A	05.12.09	NEW ISSUE	
B	08.12.19	$\phi 3.40$ & $\phi 4.1$ WERE $\phi 3.600$ & $\phi 4.14$ (SHT 2 & 4); ADD MFG NOTE AND TOL (SHT 3); MATL SPEC WAS MIL-S-5019	



D3477-041 BLOWER MOTOR INLET ADAPTER

NOTES:

- 1) SPOT WELD PER DART QSI 004
- 2) FINISH: NONE
- 3) IDENTIFY WITH DART P/N D3477-041 USING FINE POINT PERMANENT INK MARKER
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

QTY -041	P/N	DESCRIPTION
X	D3477-041	BLOWER MOTOR ASSEMBLY
1	D3477-1	FLANGE
1	D3477-3	TUBE
1	D3477-5	BLOWER ADAPTER FLANGE

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

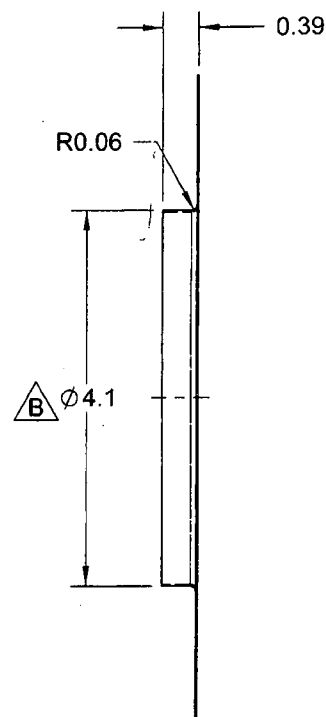
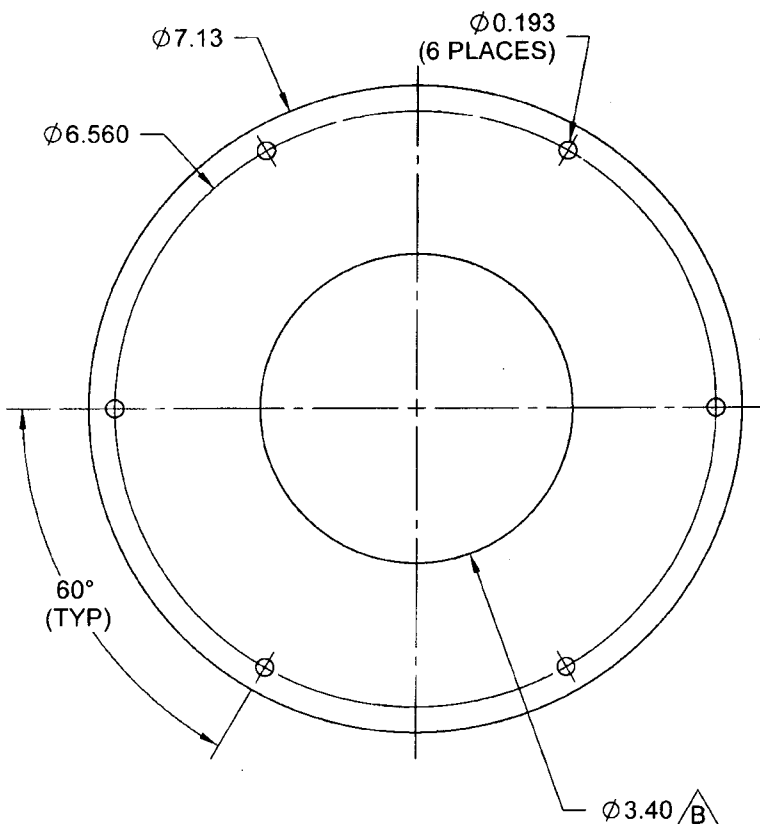
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DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3477	REV. B SHEET 2 OF 4
DATE 08.12.19		TITLE BLOWER INLET ADAPTER	SCALE 1:2

RELEASED
[Handwritten: 9/2/20 W]



D3477-1F FLANGE
FLAT PATTERN

D3477-1
FLANGE

65898

NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5059 (ANNEALED) 2B FINISH $\triangle B$
OR AMS 5513/5524, 26 GAUGE SS (0.018 THICK)
(REF. DART SPEC. M304S26GA)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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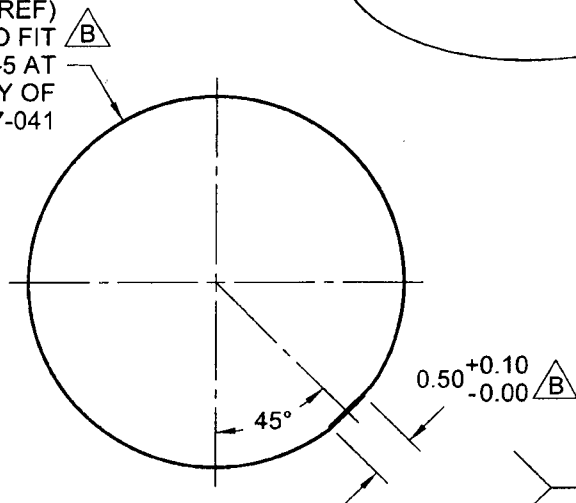
NOTE: Date & initial all entries



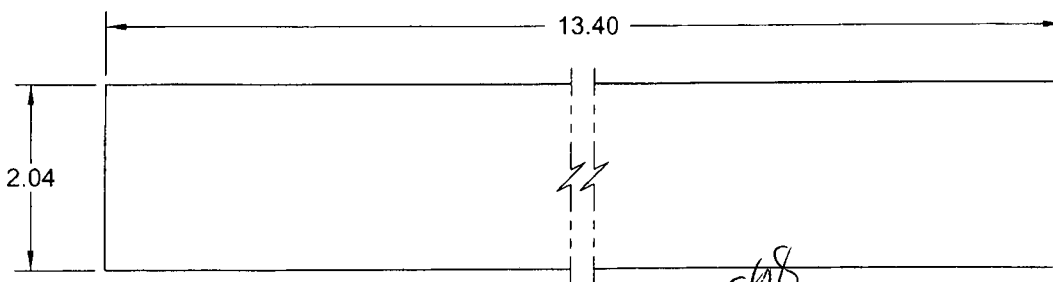
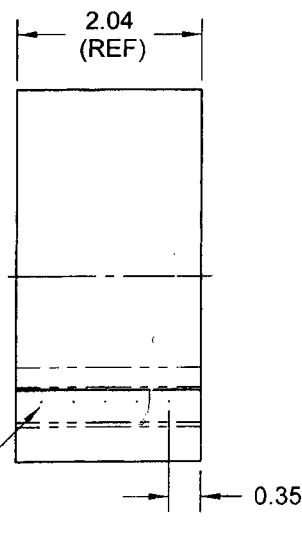
DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3477	REV. B SHEET 3 OF 4
DATE 08.12.19		TITLE BLOWER INLET ADAPTER	SCALE 1:2

RELEASED
9/12/30 *[Signature]*

Ø 4.10 (REF)
FORM TO FIT
D3477-1/-5 AT
ASSY OF
D3477-041



D3477-3 TUBE



D3477-3F TUBE FLAT PATTERN

NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5059 (ANNEALED) 2B FINISH *[Symbol]*
OR AMS 5513/5524, 26 GAUGE SS (0.018 THICK)
(REF. DART SPEC. M304S26GA)
- 2) WELD PER DART QSI 004
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

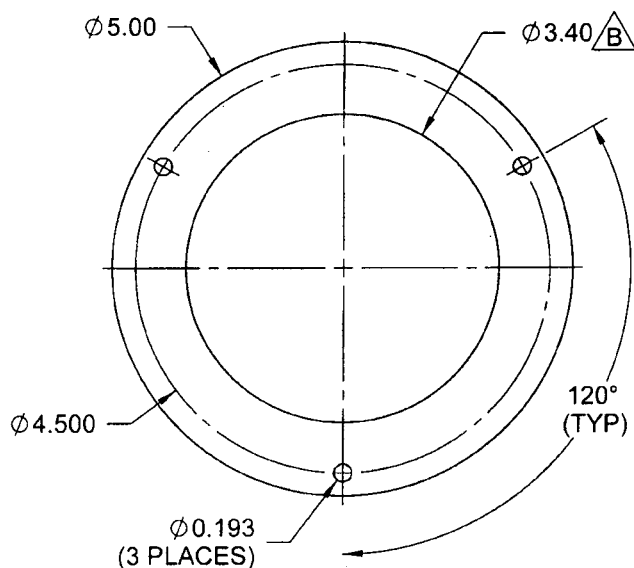
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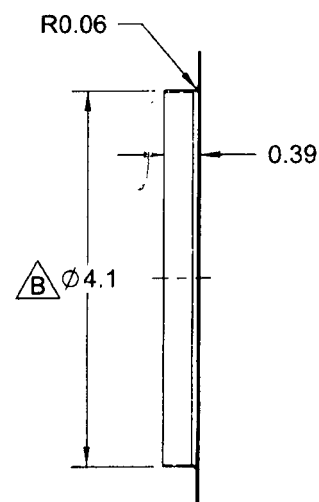


DESIGN <i>b</i>	DRAWN BY <i>b</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>pt</i>	APPROVED <i>pt</i>	DRAWING NO. D3477	REV. B SHEET 4 OF 4
DATE 08.12.19		TITLE BLOWER INLET ADAPTER	SCALE 1:2

RELEASED
01/01/20



D3477-5F FLAT PATTERN



**D3477-5 BLOWER
ADAPTER FLANGE**

NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5059 (ANNEALED) 2B FINISH $\triangle B$
OR AMS 5513/5524, 26 GAUGE SS (0.018 THICK)
(REF. DART SPEC. M304S26GA)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
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NOTE: Date & initial all entries

SPOT WELD TEST RECORD

AMS-W-6858A

CLASS 'C'

TEST NO#: 92

EMPLOYEE: Marc Gregory

PART NUMBER: D3477-041

JOB NUMBER: 1345888

MATERIAL TYPE: 304L

MATERIAL THICKNESS: .018

GROUP SPECIFICATION

☐

Group 1: Aluminum & magnesium

☐

Group 2: Iron; nickel; cobalt

☒

Group 3: Titanium SS

TEST RESULTS

	PASS	FAIL	
VISUAL:	[<u>✓</u>]	[]	
PENETRATION:	[<u>✓</u>]	[]	
PULL STRENGTH:	[<u>✓</u>]	[]	PSI Reading: _____

Qualified in accordance with standard AMS-W-6858A and QSI 004 (ref: 4.3)

DATE OF TEST COUPON: 11/02/02
QUALIFIER: SR